

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch

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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 1.28**WELDING INSPECTION REPORT****Resident Engineer:** Casey, William**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-029923**Date Inspected:** 17-Aug-2013**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1530**Contractor:** American Bridge/Fluor Enterprises, a JV**Location:** Job Site**CWI Name:** Bernie Docena, Jesse Cayabyab**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** SAS Tower**Summary of Items Observed:**

Caltrans Quality Assurance Inspector (QA) Joe Adame arrived at the American Bridge/Fluor (ABF) JV job site between the times noted above in order to monitor ABF Quality Control functions and the in process work being performed by ABF production personnel. The following items were observed:

**NDT Inspection of Electroslag Welds (ESW)**

RWR201305-009

ESW W-043, Location "V"- Face A, B:

The QA Inspector observed ABF QC Inspector Jesse Cayabyab perform Ultrasonic Testing (UT) on approx. 1000mm of Tower Electroslag Complete Joint Penetration (CJP) weld designated as ESW "V" face A,B. The inspection was being performed on SMAW repairs. Y Locations were noted as: Y=5210mm,5225mm and additional HAZ areas located 300mm above and below the prosed repair.

No rejectable or recordable indications were observed.

The QA Inspector also performed UT of the above mentioned ESW location in accordance with the ABF approved supplemental procedure for confirmation and evaluation of planar type defects. Tandem report for work performed on this date will be completed by Mr. Cayabyab and signed by both QA/QC parties. Items listed on tandem report reflect indications agreed upon by QA/QC. See TL-6027 for additional details on the items inspected on this date

**ESW Repair excavation**

RWR-201307-009

ESW E-045, Location "F"- B:

The QA Inspector was later present to observe ABF welder Kit Lai (WID-2953) performing excavation of ESW

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## WELDING INSPECTION REPORT

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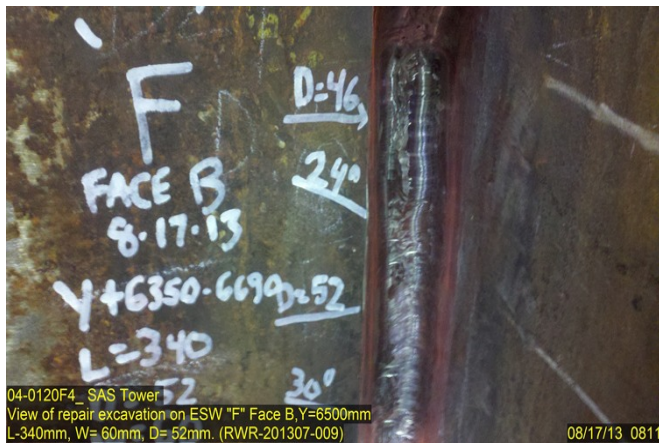
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“F” Face B @ Y-6470mm to verify indications observed during Ultrasonic Testing pulse/echo & pitch/catch. Mr. Lai was performing air carbon arc gouging and grinding on the excavation. After grinding to bright metal the ABF QC Inspector Bernie Docena performed MT testing of the excavation. Details of the final repair excavation are as follows:

WeId excavated at 52mm-No indications observed.

Excavation Length (Y=6350mm~6690mm) L=340mm, W= 60mm, D= 52mm.

The QC Inspector stated the excavation appears to be free of discontinuities and he would complete ABF daily inspection report and magnetic particle testing report to detail the findings. The QA Inspector also performed MT inspection of the final excavation. After excavation Mr. Lai set up to perform SMAW repair welding on this date. See TL-6028 for additional details on items inspected on this date.



### Summary of Conversations:

Only general conversations with ABF/JV QC NDT personnel relevant to work and testing performed during this shift.

### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Gary Thomas (916) 764-6027, who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Adame,Joe	Quality Assurance Inspector
<b>Reviewed By:</b>	Mertz,Robert	QA Reviewer

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